



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3043-042
Job Sheet 182492



Part No: D3043-042

Job Qty: 2 ea

Part Name: Step Weldment RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/24/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev :A New Issue JLM 05-11-01

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	9/14/18	9/14/18	0.00	0.00	Start Up Large Fab-4		CC
100	Large Fab	2 pcs	9/14/18	9/14/18	0.00	2.02	Large Fab 8		CC
110	QC	2 pcs	9/14/18	9/14/18	0.00	0.00	QC6		MS
120	Large Fab	2 pcs	9/14/18	9/14/18	0.00	2.02	Large Fab 8		CC
130	QC	2 pcs	9/14/18	9/14/18	0.00	0.00	QC9		MS
140	QC	2 pcs	9/14/18	9/14/18	0.00	0.00	QC5		MS
150	HandFinish	2 pcs	9/14/18	9/14/18	0.00	0.37	HandFinish1		SA 18-09-10
160	Large Fab	2 pcs	9/14/18	9/14/18	0.00	2.02	Large Fab 8		CC
170	QC	2 pcs	9/14/18	9/14/18	0.00	0.00	QC10		MS
180	QC	2 pcs	9/14/18	9/14/18	0.00	0.00	QC5		MS
190	HandFinish	2 pcs	9/14/18	9/14/18	0.00	0.37	HandFinish6		SA 18-09-13
210	Powdercoat	2 pcs	9/14/18	9/14/18	0.00	0.35	Powdercoat1		BR 18-09-13
220	HandFinish	2 pcs	9/14/18	9/14/18	0.00	0.37	HandFinish3		BR 18-09-13
230	QC	2 pcs	9/14/18	9/14/18	0.00	0.00	QC3		SEP 19 2018 68
240	Packaging	2 pcs	9/14/18	9/14/18	0.00	0.00	Packaging3-1	SEP 20 2018	SEP 20 2018 9-89
250	QC21-SA	2 Ea	9/14/18	9/14/18	0.00	0.00	QC21		SEP 20 2018 68

Part Op 100 - 1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G 2-Deburr and Descriptions: bevel ends for welding

120 - 1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808 AR AL ROD

Batch: _____ 2-Grind Fwd End Cap weld flush

160 - 1-1-Weld 1 End Cap as per QSI 004 & Dwg AR AL ROD Batch: _____ 2-Inspect for foreign object as per

QSI 024 3-Grind Fwd End Cap weld flush

210 - START Time: 2:00 OVEN TEMPERATURE: 300° FINISH TIME: 3:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	5104007
D2734	Step End Plate	2 Ea (1 ea)	120-Large Fab	5077383
D3040-1	Mounting Lug	4 Ea (2 ea)	120-Large Fab	5101878
D3040-3	Mounting Lug	4 Ea (2 ea)	120-Large Fab	5128957
D2734	Step End Plate	2 Ea (1 ea)	160-Large Fab	

Job Allocations

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	2	209	0
120-Large Fab	D2734	2	70	0
	D3040-1	4	12	0
	D3040-3	4	18	0
160-Large Fab	D2734	2	70	0
Part Specifications				
Specifications could not be found.				

Plex 8/24/18 2:23 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	AGAINST DEPA
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Date :	Step #:	QTY Effective :
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Description Work Order Deviation	Disposition

Root Cause	FAULT CATEGORY				
<table style="width: 100%;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>	Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%;"> <tr> <td style="width: 50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 50%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
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OTHER :

Date: 09/07/18

Instructions: Various STC's
 Inspector:
 Revision:
 Serial No/ Batch: S108475
 Job No: 182492
 Part: D3043-042



DART
AEROSPACE

Container No: S108475

Part: D3043-042

Job No: 182492

Serial No/ Batch: S108475

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

1270 Aberdeen Street
 Hamilton, ON K8A 1K7
 CANADA
 TEL: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaero.com

Approval

By

Supervisor
Verification

Coordinator
Approval